

Work Order ID 73291

Wednesday, August 31, 2011 10:43:18 AM



Page 1

Item ID:	D3065-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	9/1/2011	Start Qty:	50.00		Cust Item ID:	
Required Date:	9/15/2011	Req'd Qty:	50.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3065	Rev B

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3065 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-								
2034.04	Deburr if necessary								

B11-9-23

(55)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-9-23

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

counted
(25)

8/31/2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Required Date:	9/15/2011	Req'd Qty: 50.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3065								
150		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

SB 11/09/26

8 11/09/26

11/09/26

54

54

P10 →

W/O: 73291		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-7 PAR #: W/A Fault Category: Small Prob / work NCR: Yes No DQA: A Date: 11/10/03
11.864 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/10/03

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 6.13						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/26	140	Found 1 part ^{missed} at the top of the part R.C. in class to end of Sheet. Pass	<u>S</u> ASL042	Scrap & destroy	<u>S</u> 11/09/26	<u>S</u> 11/09/26	<u>S</u> 11/09/26	<u>S</u> 11/09/26

NOTE: Date & initial all entries

Work Order ID 73291

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Item ID: D3065-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Spacer

Start Date: 9/1/2011 Start Qty: 50.00

Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 50.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

54
count / 11/09/26

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

54X / 11/09/26

180

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

GA

EP 11/09/27 (54)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3065-7

Accept

Revision ID:

Item Name: Step Spacer

Start Date: 9/1/2011 Start Qty: 50.00

Required Date: 9/15/2011 Req'd Qty: 50.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27 *[Signature]*
MK
11-09-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, August 31, 2011 10:43:15 AM

Page 1

Work Order ID: 73291



Parent Item: D3065-7



Parent Item Name: Step Spacer

Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased				100	sf	174.0184	0.1574	8.284211			



2024-T3 .040 sheet



B11-9-23

Location

Loc Qty

Loc Code

MAT022

174.018421

112291

0.5

112331

0.2

113162

18.1

117684

155.218421

113162

55

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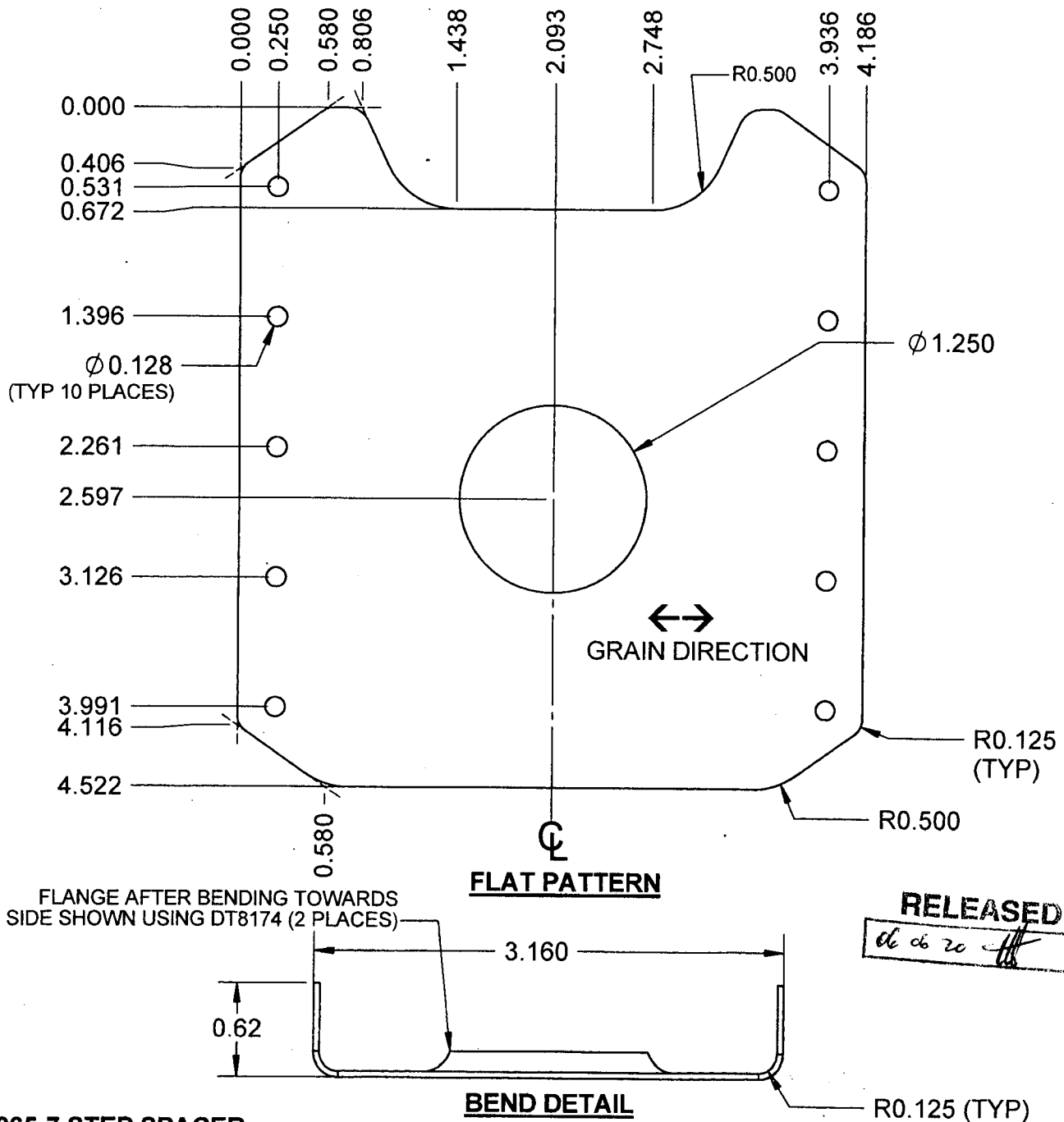
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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